

Picklist Print

October 18, 2010 7:40:42 AM

Page 1

Work Order ID: 63011



Work Order ID 63011



Page 2

Work Order ID 63011



Page 1

Item ID: D3980-041

Revision ID: PRELIM

Item Name: Bearpaw Assembly

Start Date: 10/18/10

Start Qty: 2.00

Required Date: 10/18/10

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3980

PAT Rev A

100

0.00



Pick Kit

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

110

0.00



Assembly

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Use wearbar to transfer drill hole and open to finish size as per dwg
2-- Deburr
3- Assemble as per Dwg D3980
4-Install wearplates as per dwg.

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

~~PRELIMINARY ISSUE~~

Accept

10-10-18

Cust Item ID:

Customer:

BB
10/10/18

PTC
10/10/18

BB
10/10/18

Picklist Print

October 18, 2010 7:40:58 AM

Page 2

Work Order ID: 63011

Parent Item: D3980-041

Parent Item Name: Bearpaw Assembly

Start Date: 10/18/10

Required Date: 10/18/10

Start Qty: 2.00

Required Qty: 2.00

D3980-1

Manufactured

No

B 63010

100

Each

0.0000

1

2



429 Bearpaw

D4015-041

Manufactured

No

100

Each

56.0000

7

14



Wearbar Weldment

Location

Loc Qty

Loc Code

ST109

56

53818
53956

45

11

3

11

D4211-043

Manufactured

No

B62514 x2

100

Each

0.0000

1

2



Wearplate, Aft

MS21043-3

Purchased

No

100

Each

2,532.000

7

14



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2456

111383

23

112314

2433

14

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Shop Packet Print

Page 2

Picklist Print

October 18, 2010 7:40:58 AM

Page 3

Work Order ID: 63011

Parent Item: D3980-041

Parent Item Name: Bearpaw Assembly

Start Date: 10/18/10

Required Date: 10/18/10

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

667.0000

4

8



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

627

112492

25

113069

8

114523

294

114784

300



BB 10/18/10

NAS1149D0463J

Purchased

No

100

Each

1,285.000

4

8



Washer

Location

Loc Qty

Loc Code

ST298

1285

10096

10

114576

68

115622

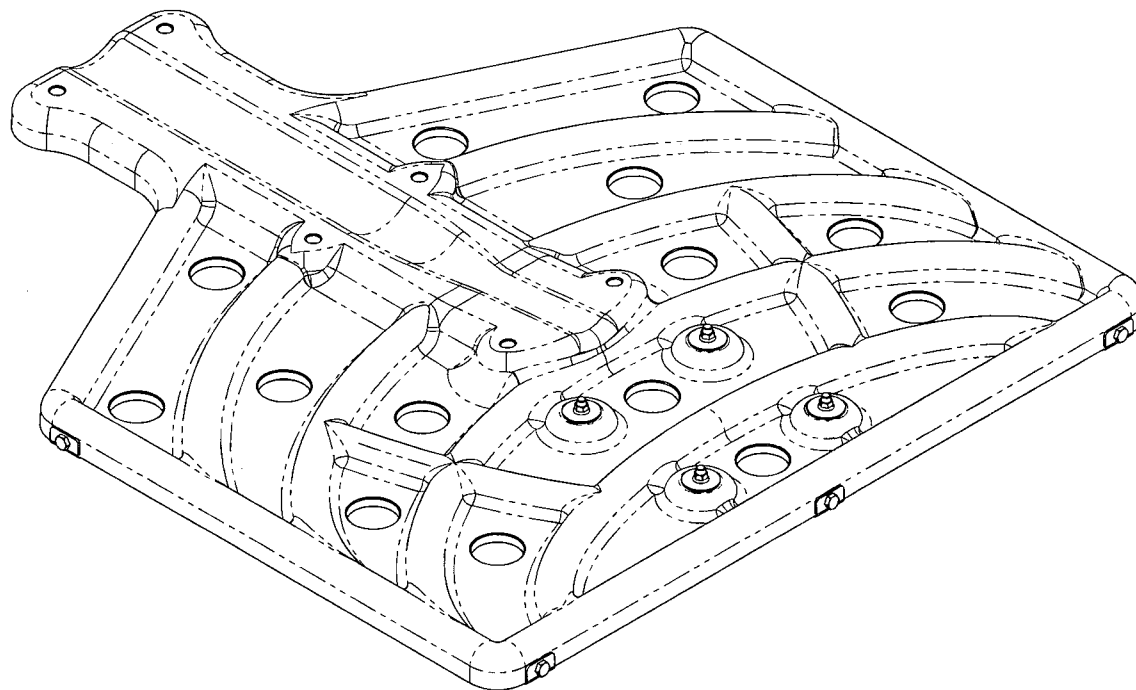
446

115647

761



BB 10/18/10



D3980-041 429 BEARPAW ASSY

PRELIMINARY ISSUE

10.09.28

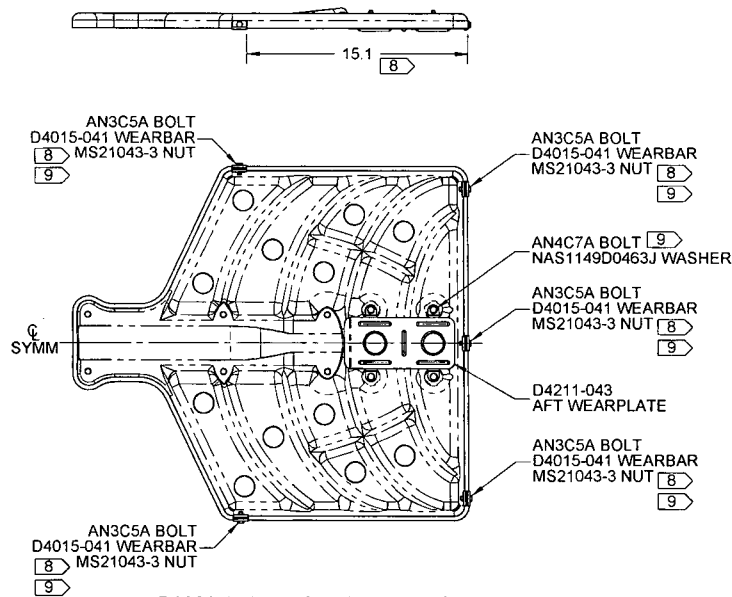
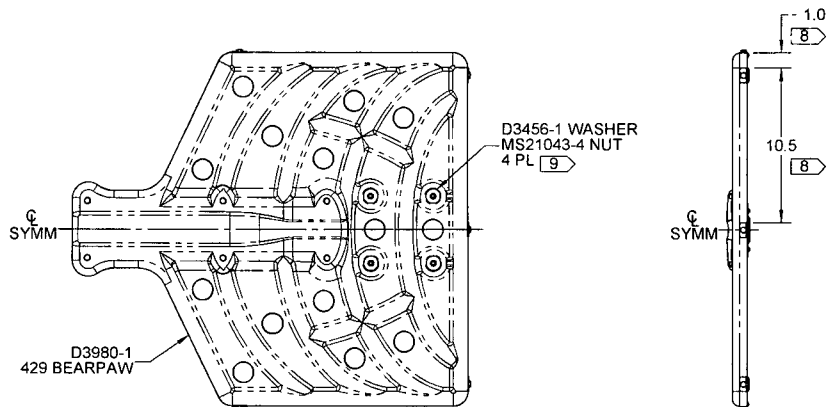
PA1	NEW ISSUE	MB	10.09.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. PA1
D3980 SHEET 1 OF 3

TITLE SCALE
429 BEARPAW ASSY NTS

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D3980-041 429 BEARPAW ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3980-041	429 BEARPAW ASSY
1	4	D3456-1	WASHER
2	1	D3980-1	429 BEARPAW
3	1	D4211-043	AFT WEARPLATE
4	5	D4015-041	WEARBAR
5	5	AN3C5A	BOLT
6	4	AN4C7A	BOLT
7	4	MS21043-4	NUT
8	5	MS21043-3	NUT
9	4	NAS1149D0463J	WASHER

PRELIMINARY ISSUE

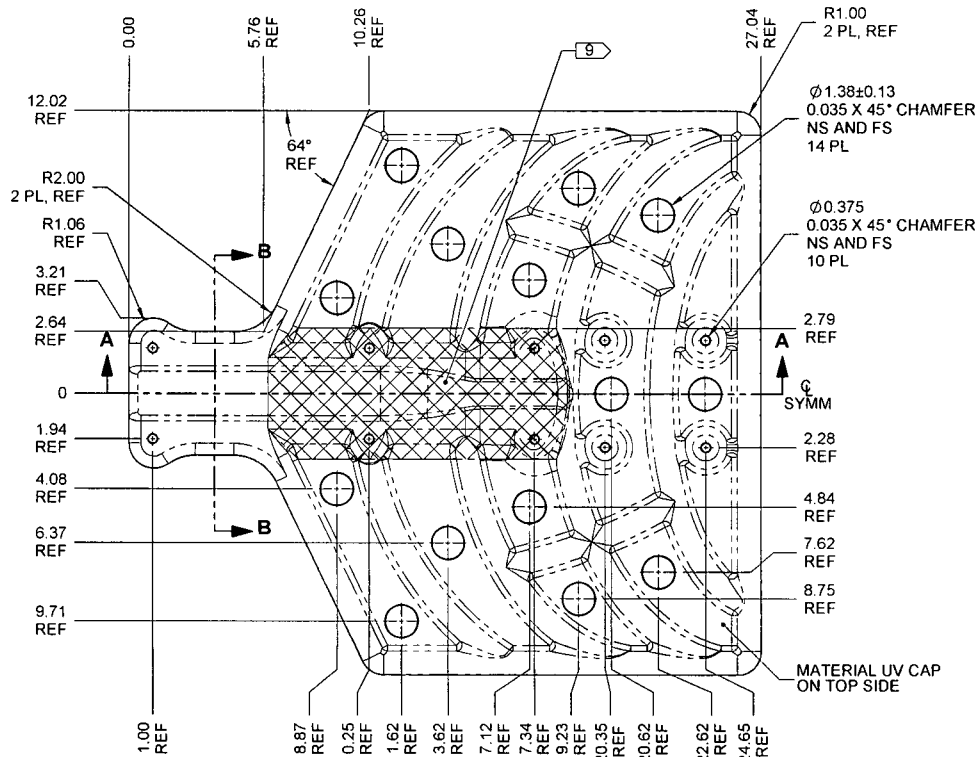
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D3980-041 NOTES:

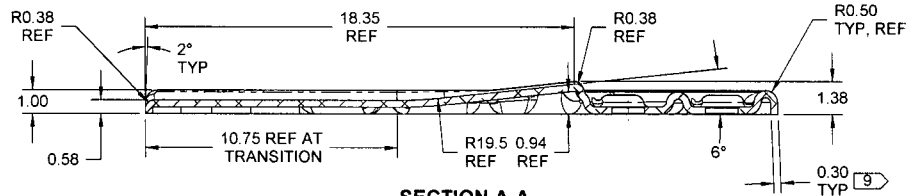
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.89 lbs
- 8) LOCATE D4015-041 (ITEM 3) AS SHOWN AND TRANSFER DRILL $\varnothing 0.191$ HOLE FROM D4015-041 TO D3980-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D3980	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		429 BEARPAW ASSY	NTS
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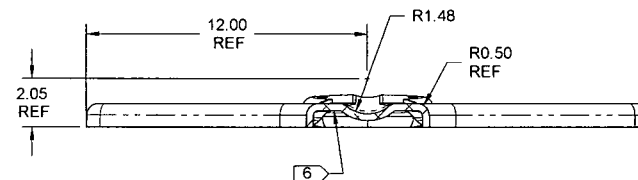
8 7 6 5 4 3 2 1



D3980-1 429 BEARPAW



SECTION A-A



SECTION B-B
VIEW ROTATED 90° CCW

PRELIMINARY ISSUE

10.09.28

D3980-1 NOTES:

- 1) MATERIAL: ALEXTRA ET SHEET, 0.300 THICK
REF. DART SPEC. M-ALXTRAB0.300
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3980-1" AND
B/N "BXXXX" PER QSI 044 6.4
- 7) WEIGHT: 8.08 lbs
- 8) THERMOFORMING: PER DT9673 AND QSI 022
- 9) MINIMUM THICKNESSES: IN SHADED AREA = 0.210
OUTSIDE SHADED AREA = 0.175

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CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D3980	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		429 BEARPAW ASSY	NTS
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

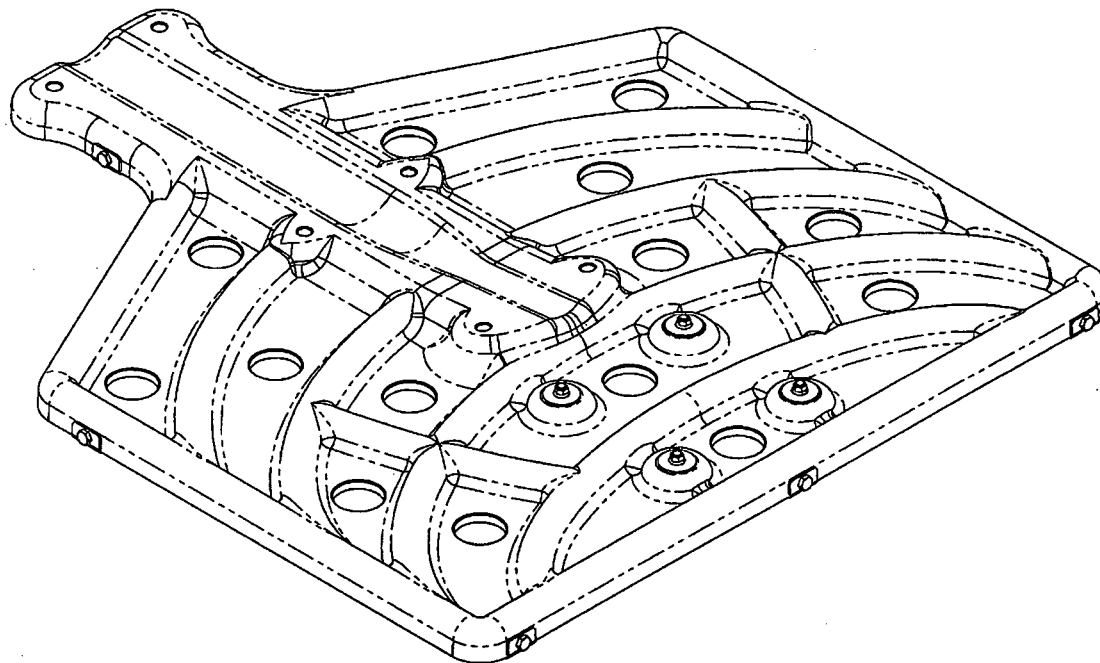
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.18	110	WEAR BARS ARE LOCATED PER TEMPLATE					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.18	110	WEAR BARS LOCATED @ 14.0" INSTEAD OF 14.9" AND 1.0" INSTEAD OF 1.0". R.C: MEASUREMENTS TRANSFERRED INCORRECTLY FROM DIG TO DIG + VICE VERSA.	 10.10.18	ACCEPTABLE DEVIATION. DRAWING SHOULD BE REVISED ACCORDINGLY.	 10/10/18		 10.10.18 Q51012	 10/10/18

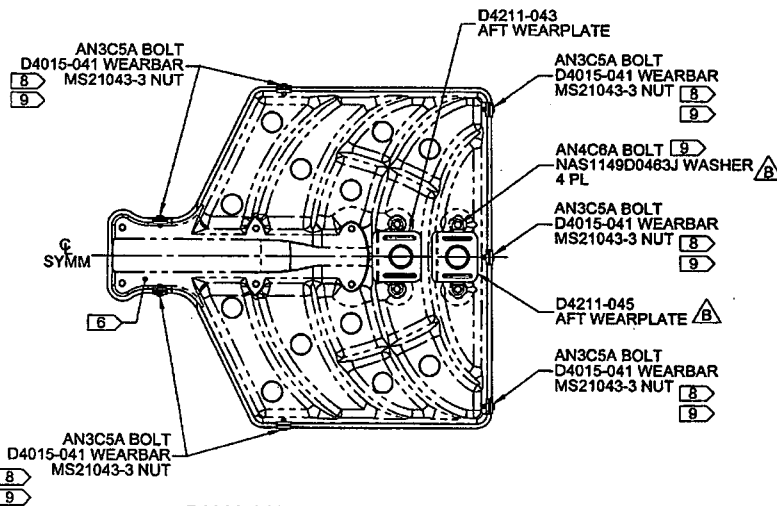
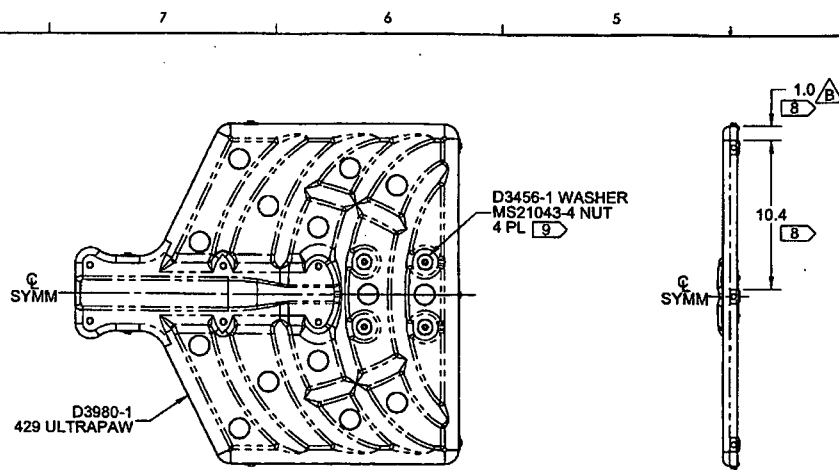
NOTE: Date & initial all entries



D3980-041 429 ULTRAPAW ASSY

RELEASED
2010-11-09
JMP

B	ULTRAPAW WAS BEARPAW; ADDED D4211-045 WEARPLATE (D4211-043 WAS SEPARATED INTO TWO - ZN A5-2 AND D3-2); REVISED NOTE 9 (A3-3) AND SHADED AREAS (D8-3) BASED ON TR-D429-793-1 REV. A; ANMCBA BOLT WERE ANMCBA BOLT (B5-2 AND D3-2); CORRECTED DIMS AS PER DRILLING JIG (WAS 14.9 (C6-2) AND 0.70 (D4-2)); ADDED RELIEF ON ULTRAPAW NOSE (A8-3, A7-3 AND A6-3).		MB	10.10.25
A	NEW ISSUE		MB	10.08.28
REV.	DESCRIPTION		BY	DATE
DESIGN	JL		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JL		DRAWING NO.	REV. B
CHECKED	SP		D3980	SHEET 1 OF 3
MFG. APPR.	SP		TITLE	SCALE
APPROVED	JL		429 ULTRAPAW ASSY	NTS
DE APPR.	JL		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.10.25			



D3980-041 429 ULTRAPAW ASSY

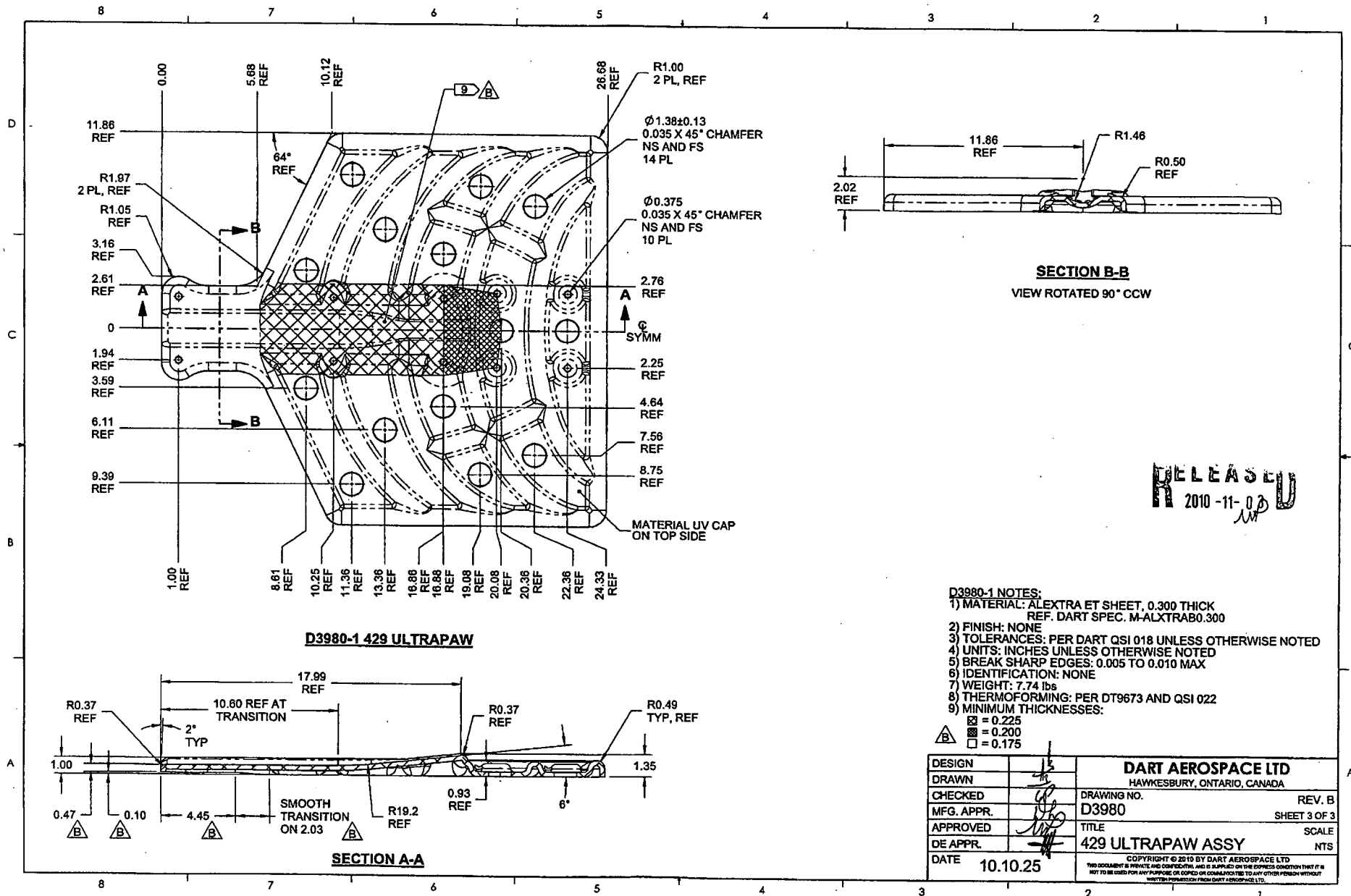
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3980-041	429 ULTRAPAW ASSY
1	4	D3456-1	WASHER
2	1	D3980-1	429 ULTRAPAW
3	7	D4015-041	WEARBAR
4	1	D4211-043	AFT WEARPLATE
5	1	D4211-045	AFT WEARPLATE
6	7	AN3C5A	BOLT
7	4	AN4C6A	BOLT
8	4	MS21043-4	NUT
9	7	MS21043-3	NUT
10	4	NAS1149D0463J	WASHER

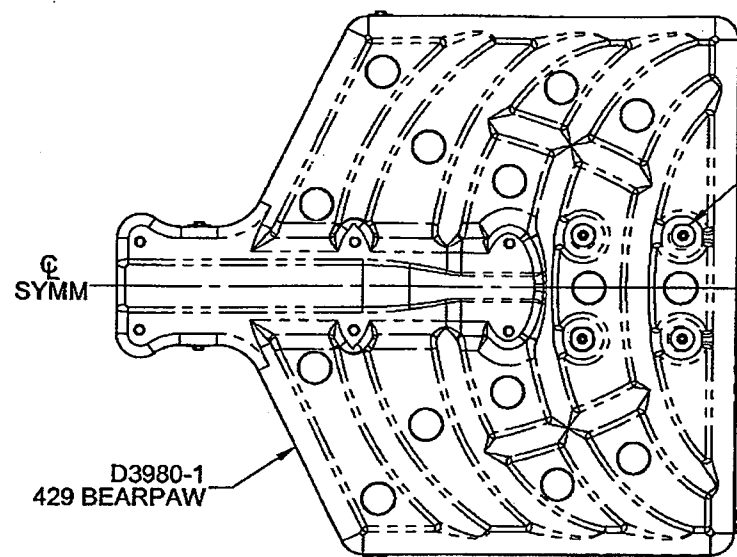
RELEASED
2010-11-03
WJ

D3980-041 NOTES:

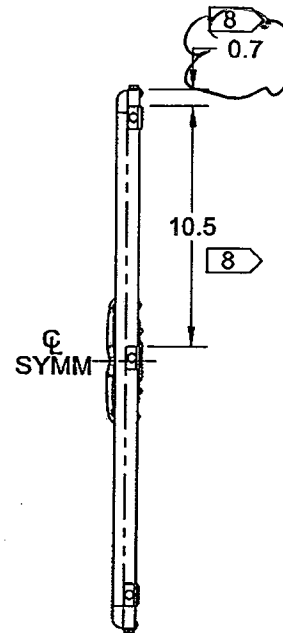
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3980-041" AND B/N "BXXXXX" PER QSI 044 8.4
- 7) WEIGHT: 8.53 lbs
- 8) LOCATE D4015-041 (ITEM 3) AS SHOWN AND TRANSFER DRILL Ø0.191 HOLE FROM D4015-041 TO D3980-1 ULTRAPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE:
AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3980	REV. B
MFG. APPR.		TITLE 429 ULTRAPAW ASSY	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.			
DATE	10.10.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BUSINESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

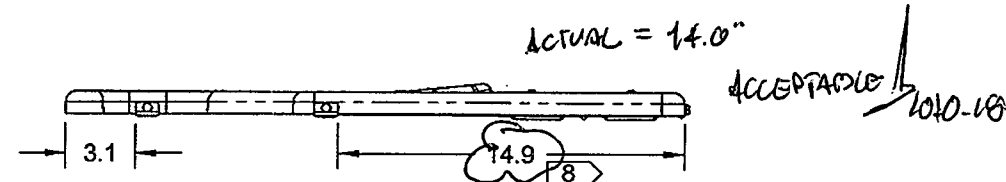




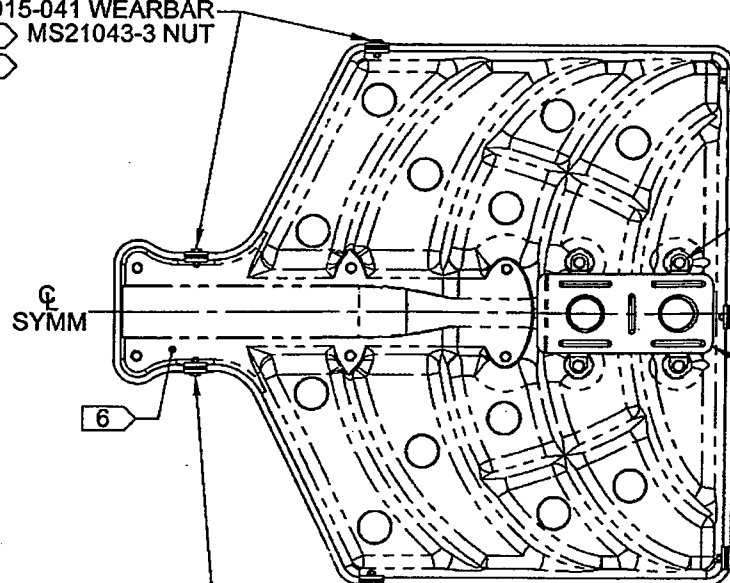
D3456-1 WASHER
MS21043-4 NUT
4 PL 9



ACTUAL = 10.7
ACCEPTABLE 10.10-10.16



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT 8 9



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT 8 9

AN4C5A BOLT 9
NAS1149D0463J WASHER

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT 8 9

D4211-043
AFT WEARPLATE

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT 8 9

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT 8 9

D3980-041 429 BEARPAW ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3980-041	429 BEARPAW ASSY
1	4	D3456-1	WASHER
2	1	D3980-1	429 BEARPAW
3	1	D4211-043	AFT WEARPLATE
4	7	D4015-041	WEARBAR
5	7	AN3C5A	BOLT
6	4	AN4C5A	BOLT
7	4	MS21043-4	NUT
8	7	MS21043-3	NUT
9	4	NAS1149D0463J	WASHER

RELEASED
2010-10-07

D3980-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3980-041" AND B/N "BXXXXX" PER QSI 044 6.4
- 7) WEIGHT: 8.62 lbs
- 8) LOCATE D4015-041 (ITEM 3) AS SHOWN AND TRANSFER DRILL Ø0.191 HOLE FROM D4015-041 TO D3980-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3980	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE 429 BEARPAW ASSY	SCALE NTS
DE APPR.			
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